

Date: Tuesday, 4/25/2006 7:35:41 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 26797		
Estimate Number	: 11473		
P.O. Number	: N/A	Part Number	: D3140301
This Issue	: 4/25/2006 S.O. No. : N/A	Drawing Number	: D3140 REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D1
Previous Run	: 25734	Material	: N/A
Written By	: See A COMMENT BELOW	Due Date	: 5/1/2006
Checked & Approved By	: HF 06.04.25	Qty:	1
Comment	: Est. A0011.06 New issue KJ/RF Est. Rev B New dwg rev. ecn781 06.04.18 EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
		 Comment: Qty.: 2.9166 sf(s)/Unit Total : 2.9166 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063) Batch: <u>M19326</u> Identify as D3140-301
2.0	SHEAR	SHEAR Comment: SHEAR Water Jet Cutblanks: 48.700" x 7.350" ORD rev: D1 Dwg rev: D1 <u>06.04.25 (4)</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3140-301 as per Folio FA316 and Dwg D3140 Deburr <u>06.04.25 (4)</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>06.04.25 (4)</u>
5.0	QC8	SECOND CHECK Comment: SECOND CHECK <u>06.04.25 (4)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:41 AM
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Drawing Name: DOUBLER

Job Number: 26797

Part Number: D3140301

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	Mel F. 06-04-27.
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	U 06-04-27
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	U 06-04-27
9.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	DP 06/04/08

Job Completion



U 06-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A 02.04.18		NEW ISSUE	
B 03.01.23		REMOVE -65/-81/-83; ADD -301/-303	
C 04.11.08		CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D 05.11.23		ADD -103/-104/-105/-106; REMOVE -67	
D1 <i>MM</i> 06.03.31		1.75 WAS 1.88; 4.75 WAS 4.13	

*PHOTOGRAPHED
05.12.01 *MM**

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
				X		D3140-09	DOUBLER ASSEMBLY
					X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
			1			D3140-91	DOUBLER
				1		D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
1						D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
			1			D3140-105	DOUBLER
				1		D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
1		1	1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET
							WORK ORDER NO. <i>Z6791</i>

D

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WITHOUT NOTICE

WORK ORDER

NO. *Z6791*

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CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05.12.01 *ff*



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



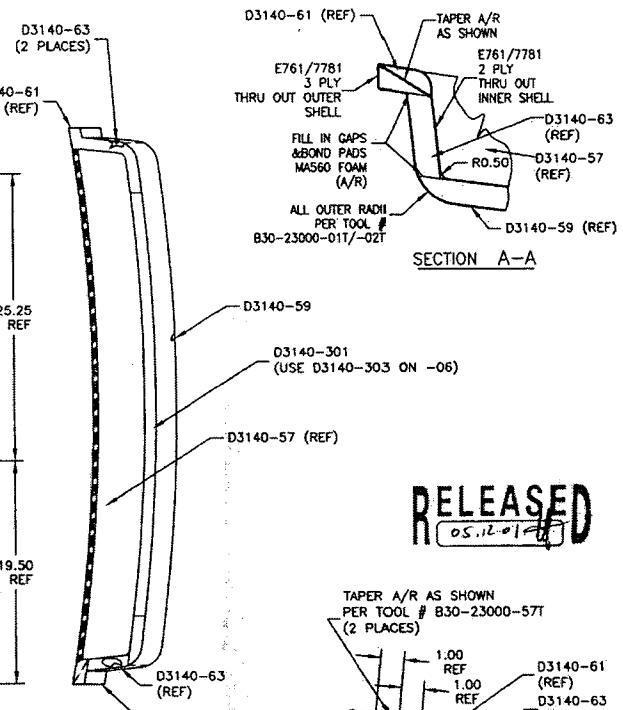
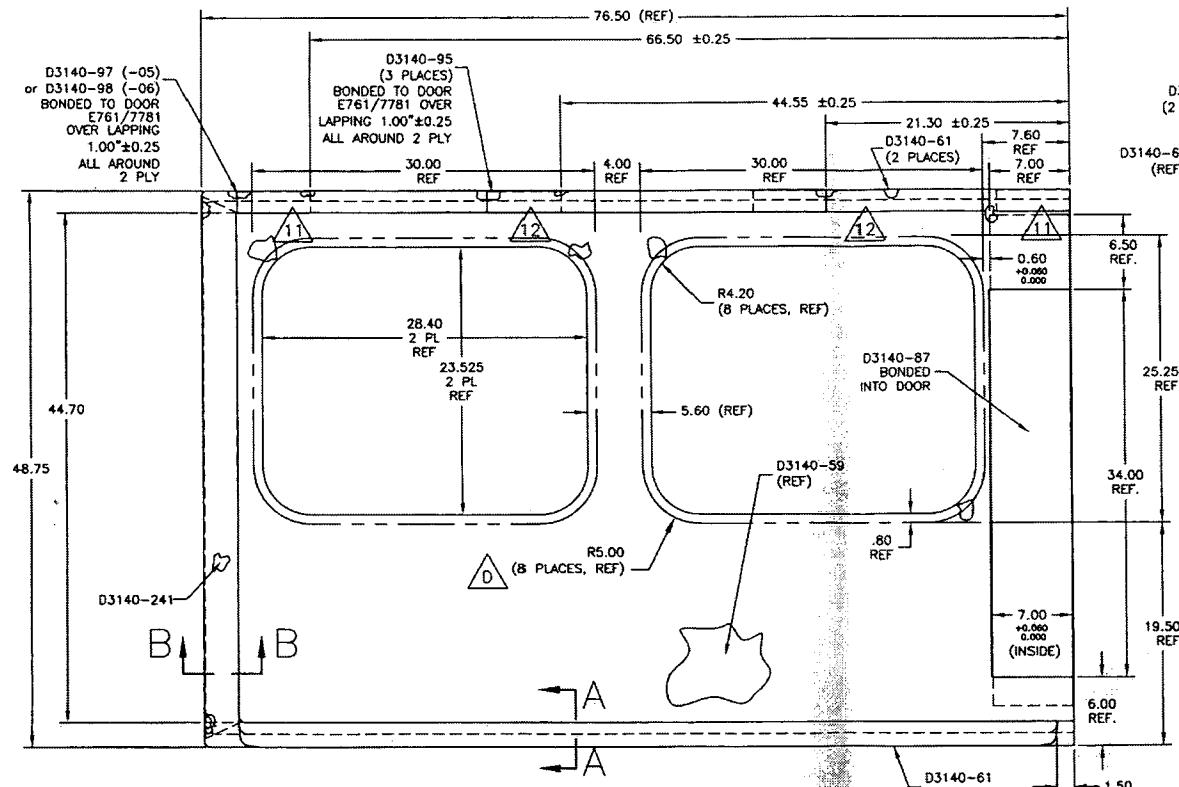
RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

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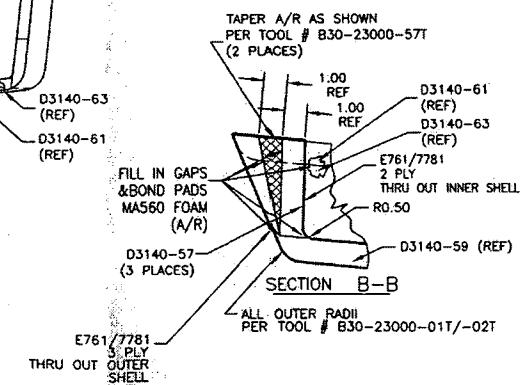
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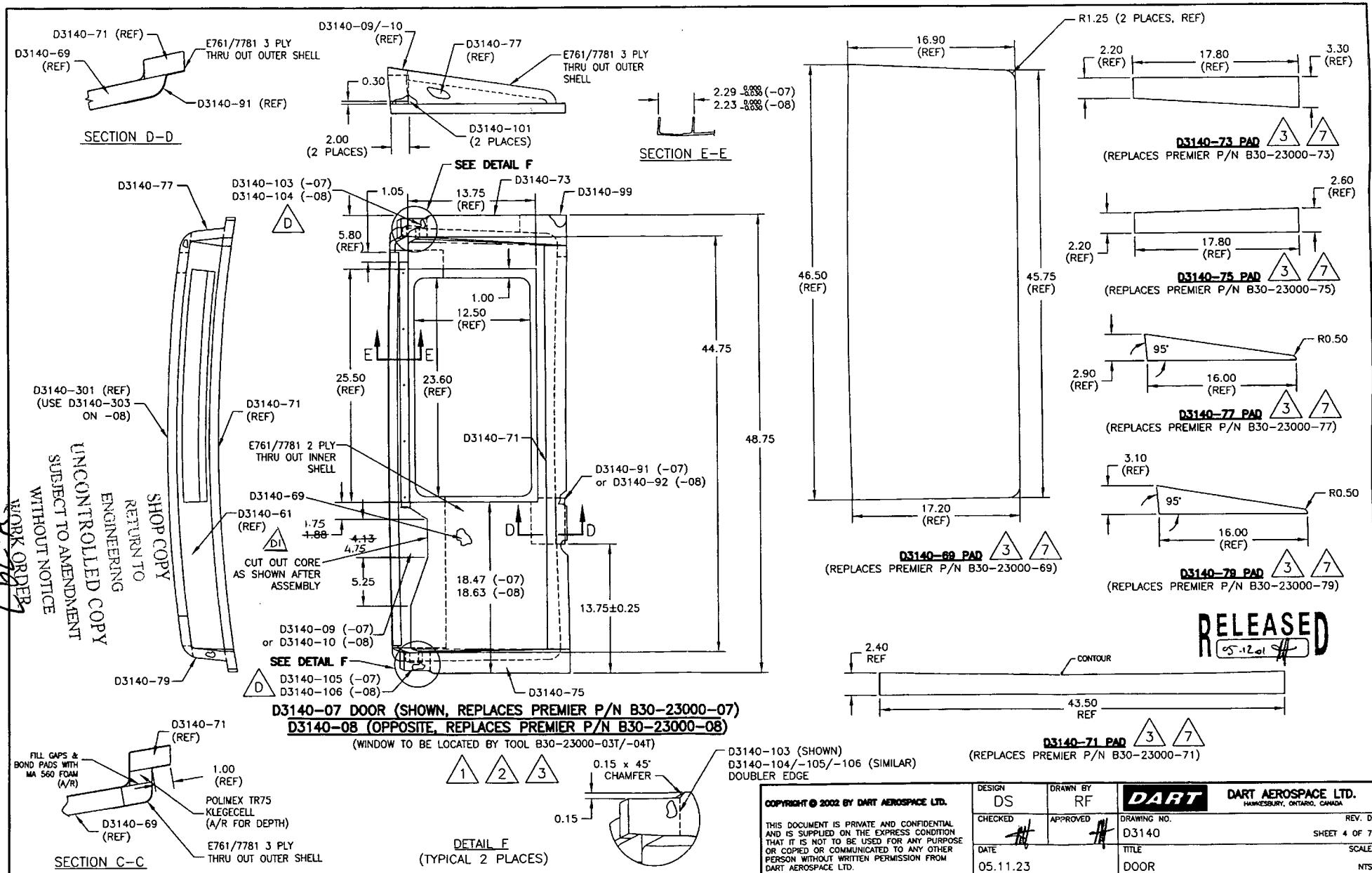
D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

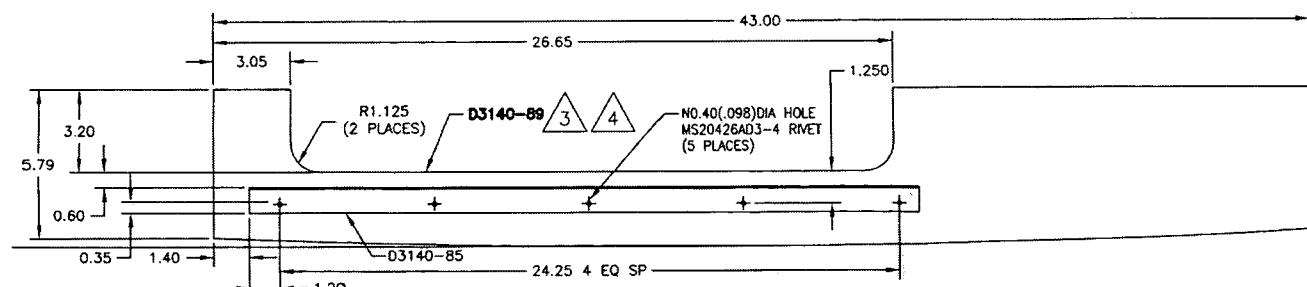
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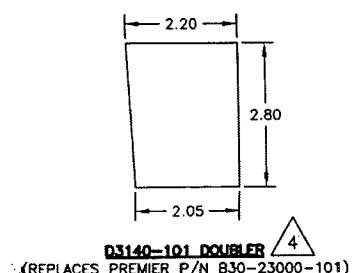
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DATE 05.11.23		TITLE DOOR	SCALE NTS	

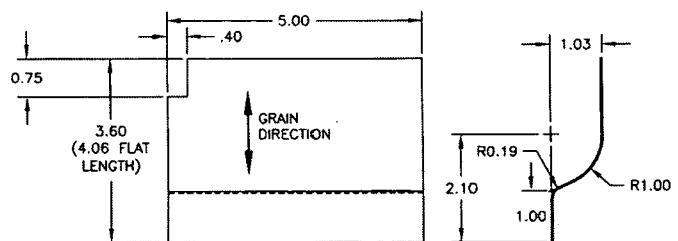




D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)
D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)

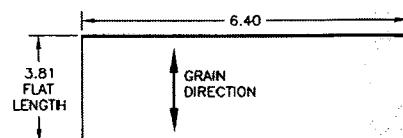
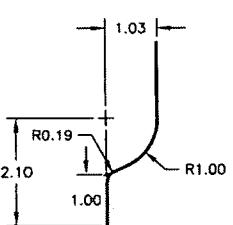


D3140-101 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-101)



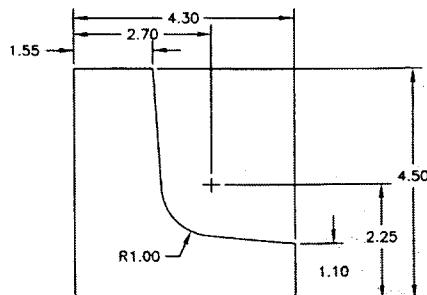
D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-91 DOUBLER 4
 (SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)

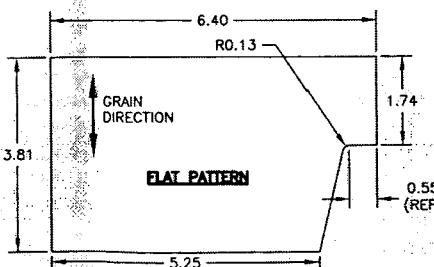


D3140-95 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-95)

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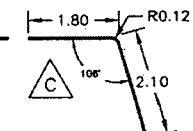


D3140-99 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-97 DOUBLER 4
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



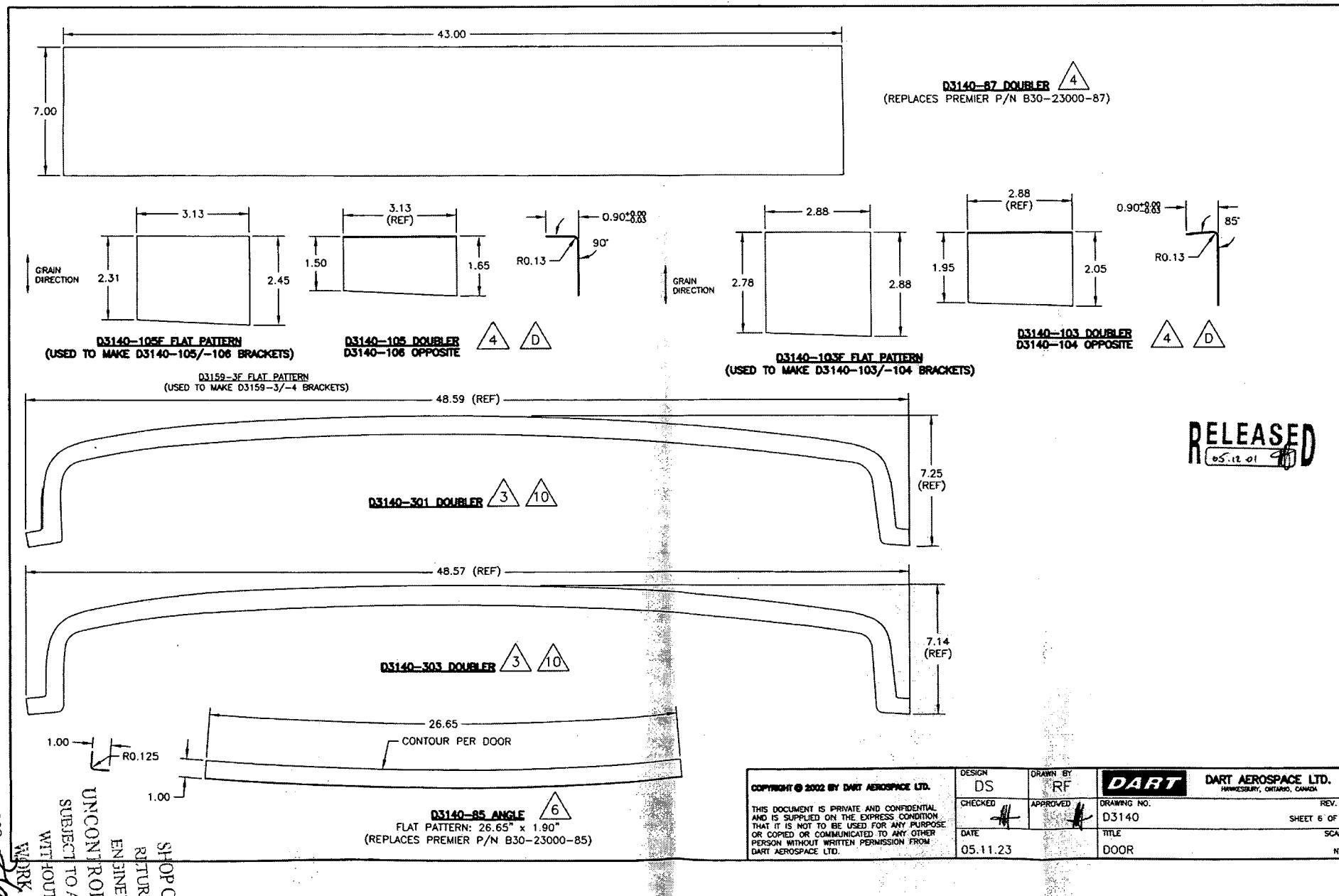
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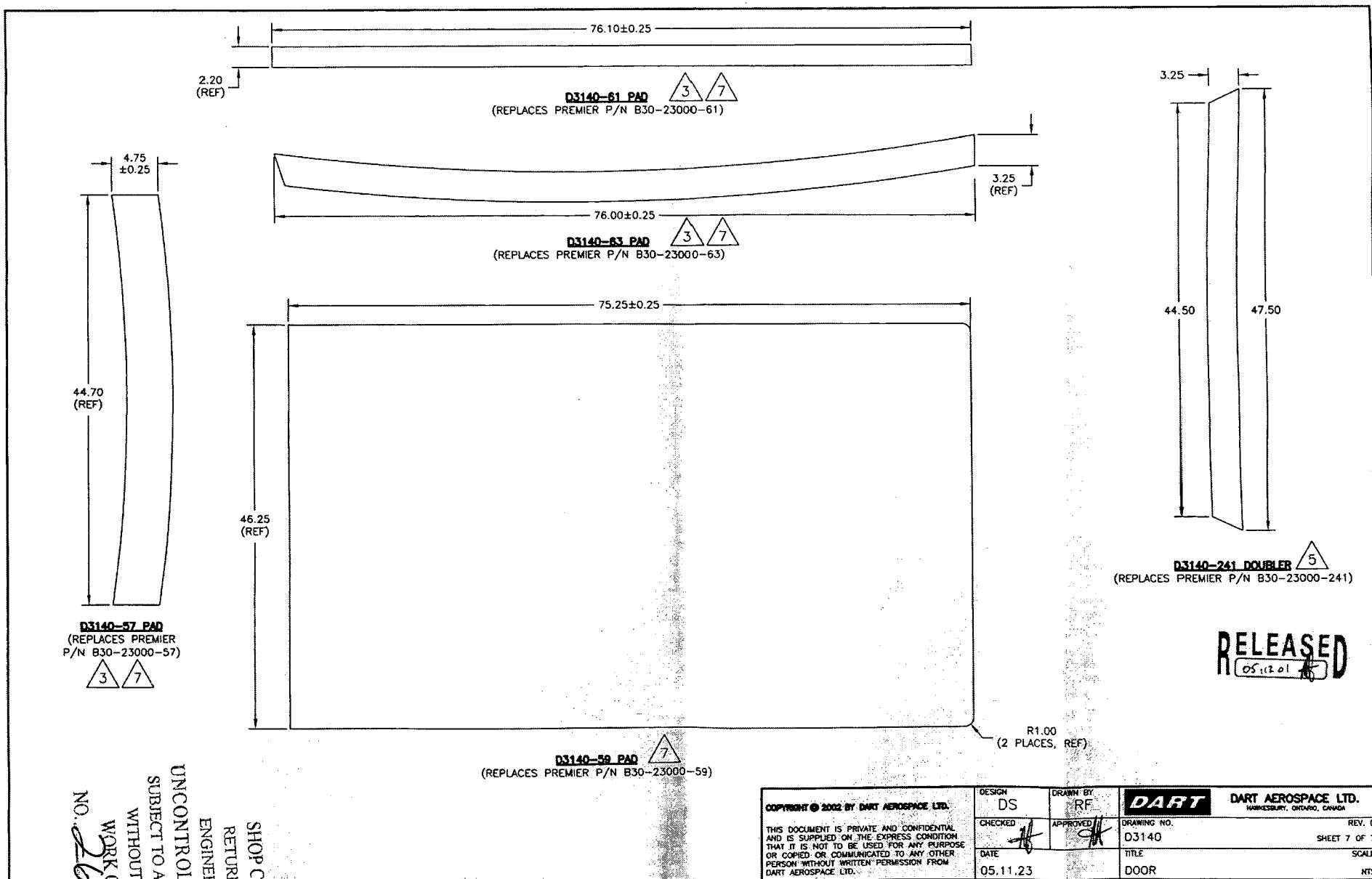
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DATE 05.11.23		TITLE DOOR	SCALE NTS

DART AEROSPACE LTD	Work Order:	26797
Description:	Part Number:	D3140-301
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>ME</u>	Audited by:	<u>EC</u>	Prototype Approval:	
Date:	<u>06.04.25</u>	Date:	<u>06.04.25</u>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	